

Date: Wednesday, 1/23/2008 11:34:01 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FUEL SCUPPER ASSEMBLY  
 Job Number : 36917A  
 Estimate Number : 10152  
 P.O. Number :  
 This Issue : 1/23/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D3270041  
 First Issue : 1/1 Type : LARGE FAB ASSY Drawing Number : D3270 REV B  
 Previous Run : 24076A Drawing Revision : B  
 Material :  
 Due Date : 2/29/2008 Qty: 20 Um: Each  
 Written By :  
 Checked & Approved By : 08 01 23  
 Comment : Est Rev: A New Issue 05-11-01 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 36917A01

2.0 M6061T6T0375W035 6061-T6 Tube .375 x.035W



Comment: Qty.: 0.6999 f(s)/Unit Total: 13.9986 f(s)

Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 0.375 OD x 0.035" wall(M6061T6T0.375W.035)

Identify as D3270-3

Batch: M104913 & 8 / M104921 & 12

FF 08-01-30

20

3.0 SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Cut D3270-3 as per Dwg D3270

FF 08-01-30

(20)

4.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3270-3 to D3270-1 as per Dwg D3270 using welding Jig D3270-041T1 and QSI 004.

SAD 08/03/01 20

PD 08-02-02 (20)

5.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/04/01 (20)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/01 (20)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-04-01 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 1/23/2008 11:34:01 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL SCUPPER ASSEMBLY

Job Number: 36917A

Part Number: D3270041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

POWDER COATING

POWDER COATING



M107550



(20X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l

08/04/01

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



yy



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-02

(20X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf. 08-04-08

h

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

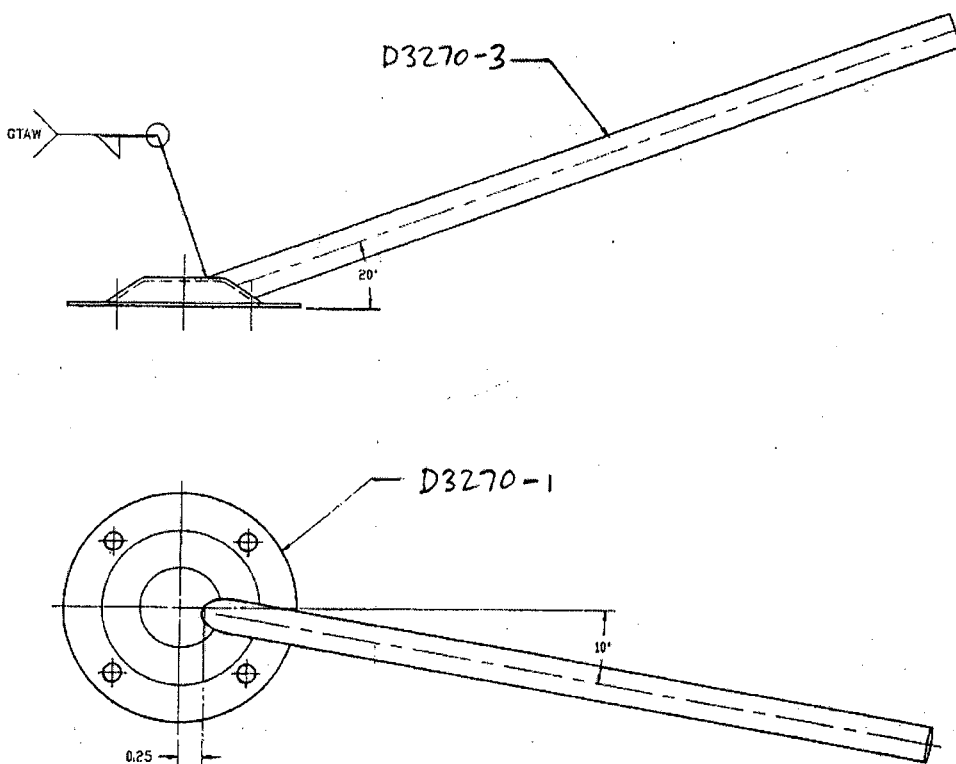
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN AA	DRAWN BY AA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED AA	DRAWING NO. D3270	REV. B SHEET 1 OF 2
DATE 05.07.14		TITLE FUEL SCUPPER DRAIN ASSEMBLY	SCALE NTS
A	04.02.20	NEW ISSUE	
B	05.07.14	ADD D3270-1 FLAT PATTERN	

RELEASED  
04.02.23



D3270-041 FUEL SCUPPER ASSEMBLY

- NOTES:
- 1) WELD PER DART QSI 004 USING 5356 FILLER ROD.
  - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER QSI 005 4.3
  - 3) ALL DIMENSIONS ARE IN INCHES
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) CONTOUR MAY BE ALTERED TO DOMED SHAPE AT FABRICATOR'S DISCRETION

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36917A

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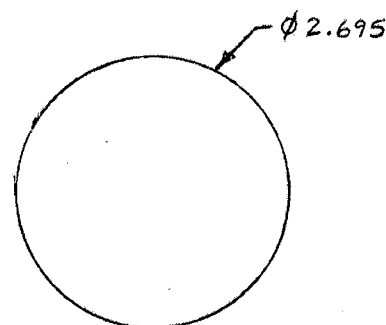
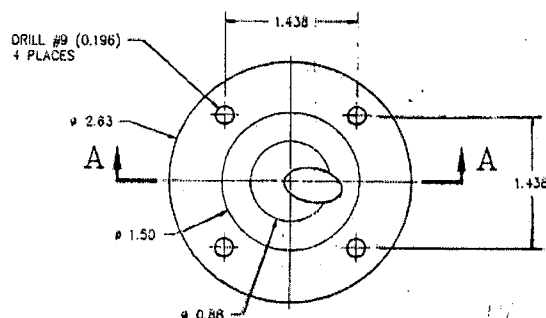


DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3270
				REV. B
DATE	05.07.14	TITLE	FUEL SCUPPER ASSEMBLY	SHEET 2 OF 2
				SCALE MT3
A	04.02.20	NEW ISSUE		
B	<del>04.02.20</del> 05.07.14	ADD D3270-1 FLAT PATTERN		

RELEASED  
04.02.23 *[Signature]*



SECTION A-A

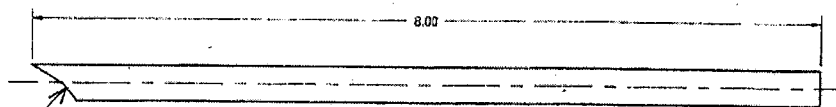


D3270-1 FLAT PATTERN



D3270-1 MOUNTING BASE

MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER QQ-A-250/11 (M6061T6S.040)



CONTOUR TO FIT  
D3270-1



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D3270-3 FUEL OUTLET TUBE

MATERIAL: 6061-T6 ALUMINUM TUBING 0.375" OD X 0.035" WALL (SEAMLESS)  
PER MW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8  
(M6061 T6 T 0.375 W 0.035)

36917A

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